

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013319**Date Inspected:** 21-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11, Tower Strut Flange Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ND1-STSA4-6-143M-2-7A/B, 8A/B

ND1-STSA4-6-143M-1-7A/B, 8A/B

ED1-STSA4-6-143M-2-7A/B, 8A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER GRILLAGE PLATE

SAW welding of weld joint 9B located on GTSA5-B/G.

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Welder is identified as 042195. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 10B located on GTSA5-B/G.

Welder is identified as 047304. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

EAST TOWER LIFT 4, FIT LUG

FCAW welding of weld joint 111 located on ESTL4-2C/L.

Welder is identified as 040759. ZPMC QC is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

WEST TOWER LIFT 5, AB CORNER REPAIR

SMAW welding of weld joint 20A/B(Repair) located on WSD1-TL5-4B/F.

Welder is identified as 040690. ZPMC CWI is identified as Mr. An Qing Xiang.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR.

PADEYE ON TOWER SKIRT PLATE

SMAW welding of weld joint 18 located on WSD1-A804A/B.

Welder is identified as 251194. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-PADEYE.

BAY 10

TOWER FACADE PLATE

SAW welding of weld joint 12 located on SD1-SFSA4-7A/B.

Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
